- 1. (original) An article made of a magnesium alloy tube, the article having a grain size of between  $10\mu m$  and  $50\mu m$  and being manufactured by internal high pressure forming.
- **2.** (original) An article according to Claim 1, wherein the temperature of the internal high pressure forming is between 200°C and 605°C.
- **3.** (original) An article according to Claim 1, wherein the tube was manufactured by extrusion.
- **4.** (original) An article according to Claim 3, wherein the extrusion temperature is between 300°C and 605°C.
- **5.** (original) An article according to Claim 3, wherein the extrusion speed is substantially between 5 mm/sec and 45 mm/sec.
- **6.** (original) An article according to Claim 3, wherein the extrusion reduction ratio is substantially between 10:1 and 50:1.
- 7. (original) An article according to Claim 3, wherein the extrusion temperature is between 300°C and 605°C, the extrusion speed is substantially between 5 mm/sec and 45 mm/sec, and the extrusion reduction ratio is substantially between 10:1 and 50:1.
- **8.** (currently amended) An article according to any one of the above claims, Claim 1, wherein the magnesium alloy is selected from the group consisting of AZ31 and ZM21.
- **9.** (original) An article according to Claim 8, wherein the extrusion reduction ratio is substantially 30:1, the extrusion speed is substantially 15 mm/sec, the predetermined temperature is substantially 300°C, and the AZ31 alloy is used.
- **10.** (original) An article according to Claim 1, wherein the magnesium alloy comprises 2.856% aluminum, 1.022% zinc, 0.329% manganese, 0.004% iron, 0.038% silicon, 0.001% copper, and 0.001% nickel.

- **11.** (original) An article according to Claim 1, wherein the tube is annealed.
- **12.** (original) An article according to Claim 11, wherein the tube is annealed at a temperature of 300°C for six hours.
- **13.** (original) A process for manufacture of a tube from a billet made of a magnesium alloy, the process comprising:
  - (a) heating the billet to a predetermined temperature that is within a range of 300°C to 605°;
  - **(b)** extruding the billet, using an extrusion press having a ram, an internal piercing mandrel, and a die, while maintaining the temperature of the billet to stay within the range; and
  - (c) applying a force to the billet so that it is forced between the die and the mandrel at a predetermined extrusion speed of the ram to form a tube having a predetermined extrusion reduction ratio;

wherein the extrusion speed is substantially between 5 mm/sec and 45 mm/sec, and the extrusion reduction ratio is substantially between 10:1 and 50:1.

- **14.** (original) A process according to Claim 13, wherein the magnesium alloy is selected from the group consisting of AZ31 and ZM21.
- **15.** (original) A process according to Claim 14, wherein the extrusion reduction ratio is substantially 30:1, the extrusion speed is substantially 15 mm/sec, the predetermined temperature is substantially 300°C, and the AZ31 alloy is used.
- **16.** (original) A process according to Claim 1, wherein the magnesium alloy comprises 2.856% aluminum, 1.022% zinc, 0.329% manganese, 0.004% iron, 0.038% silicon, 0.001% copper, and 0.001% nickel.

- **17.** (original) A process according to Claim 1, wherein the process further comprises the step of annealing the tube.
- **18.** (original) A process according to Claim 17, wherein the tube is annealed at a temperature of 300°C for six hours.
- **19.** (original) A process according to Claim 13, further comprising the steps of
  - (d) cooling the tube at a predetermined first cooling temperature for a predetermined amount of time;
  - (e) sealing the tube from both ends;

. . . .

- (f) introducing a pressure medium into the tube;
- (g) positioning the tube in a mold having a guiding zone at a predetermined guiding temperature and an expansion zone of a predetermined shape at a predetermined expansion temperature;
- (h) applying an axial compression force on the tube so that a section of the tube located in the expansion zone expands to conform to the predetermined shape; and
- (i) cooling the tube at a predetermined second cooling temperature for a predetermined amount of time;

wherein the expansion temperature is within a range of 200°C to 605°.

- **20.** (original) A process according to Claim 19, wherein the expansion temperature is substantially between 200°C and 500°C.
- **21.** (original) A process according to Claim 19, wherein the pressure medium is a gas.
- **22.** (original) A process according to Claim 21, wherein the gas does not react with the metal under the conditions used in the process.
- **23.** (original) A process according to claim 19, wherein the pressure medium is a heat resistant liquid.